

Date: Tuesday, 11/29/2005 7:07:47 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 25065
 Estimate Number : 10472
 P.O. Number : N/A
 This Issue : 11/29/2005 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : N/A
 Written By :
 Checked & Approved By :
 Comment : Created By Auto Work Order

Drawing Name : JET TUBE
 Part Number : D2409
 Drawing Number : D2409 REV. A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 12/11/2005 Qty: 5 Um: Each

Additional Product

Job Number:



Seq.	Machine Or Operation:	Description :
1.0	M6061T6T0500W035	6061-T6 Tube .500 x.035W

Comment: Qty.: 1.6666 f(s)/Unit Total : 8.3330 f(s)
 6061-T6 Tube 0.50 x .035W
 Material: 6061-T6 (0.50" OD x 0.035") wall seamless tubing (M6061T6T0.500W.035) Batch: M4692
 FF 05.12.05

PTO

Tools:

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

~~Fit flared longer end of tube only~~

- 1- Cut as per template D2409T1
- 2- Deburr
- 3- Bend as per template D2409T2 & Dwg D2409
- Identify as D2409

FF 05.13.06

Tools:

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.05.16 (S)

Tools:

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location:

06/05/16 (S)

Tools:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05-11-06	2	Dwg change in step 2 change. Add dims to measure and inspect part. Permanent change as shown.	J	Cancel not on this w/o 06-05-15		AB 05-12-06	AB 05-12-06

Part No: D2409 PAR #: N10 Fault Category: Prod / FAB ASS' med & small NCR: Yes/No DQA: Date: 06/05/17
 QA: N/C Closed: Date: 06.05.18

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-12-06	1	Sx D2409 were made of .500" x .035" SS tubing, 80°	AB AB/AB	SCRAP AND DESTROY MAT/1 AND REPLACE REPLACE WITH A1. AS PER Dwg D2409 AND I.P.P. Instructions. Ensure employee understands the type of material needed.	FF 05.12.06	J	AB 05-12-06	J 05-12-06

NOTE: Date & initial all entries

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Seq.#: Machine Or Operation:

Description :

5.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

OP 06/05/17

(G)

Tools:

Job Completion



U 06.05.17

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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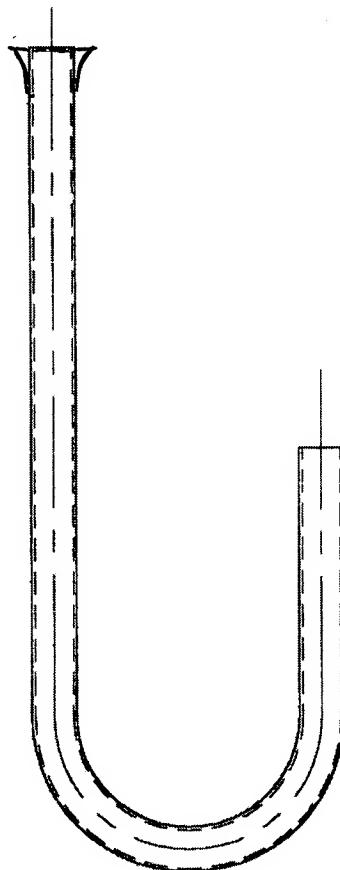
NOTE: Date & initial all entries

DART



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	REV. A D2409 SHEET 1 OF 1
DATE Apr. 6, 1995		SCALE JET TUBE 1:2

RELEASED
96/09/10 BLJ



MATERIAL: 0.50 OD 0.035 WALL AL
BEND PER TEMPLATE TD2409